



Dart Aerospace Ltd.
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D3913-041
Job Sheet 176188



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/18/18

Job Tracking No:

Due Date: 5/21/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/18/18	5/18/18	0.00	0.00	Start Up Large Fab-5		D.M. 18-5-3
100	Large Fab	1 pcs	5/19/18	5/19/18	0.00	10.00	Large Fab 1		14-5-18
110	QC	1 pcs	5/19/18	5/19/18	0.00	0.00	QC9		21-05-15
120	QC	1 pcs	5/19/18	5/19/18	0.00	0.00	QC5		21-05-15
125	HandFinish	1 pcs	5/19/18	5/19/18	0.00	0.29	HandFinish2		18-5-17
130	Powdercoat	1 pcs	5/19/18	5/19/18	0.00	0.93	Powdercoat2		18-5-17
135	Packaging	1 pcs	5/19/18	5/19/18	0.00	0.00	Packaging1		18-5-17
140	QC	1 pcs	5/19/18	5/19/18	0.00	0.00	QC3		11-5-12
150	HandFinish	1 pcs	5/21/18	5/21/18	0.00	0.50	HandFinish4		18-5-17
160	QC	1 pcs	5/21/18	5/21/18	0.00	0.00	QC5		18-5-17
170	Packaging	1 pcs	5/21/18	5/21/18	0.00	0.00	Packaging3-2		18-5-17
180	QC21-SA	1 Ea	5/21/18	5/21/18	0.00	0.00	QC21		21 MAY 22 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138839. START 1/2/00 OD: Ti 345 FINISH 1/2/15.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5054665
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5061862
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5058261
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5061952
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5054996
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5058004
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5061468
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5065866
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5062521
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5058574
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5060227
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5057511
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5058263
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5059794
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5062265
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5054936
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5066124
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5041427
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	18643
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5042891
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5054102
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5068663
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5054022

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	72	0
	D3913-1	1	15	0
	D3913-15	1	18	0
	D3913-3	1	17	0
	D3913-7	2	15	0
	D3913-9	1	9	0
	D3916-041	2	20	0
	D3916-5	3	20	0
	D4016-1	3	4	0
	D4017-7	3	57	0
	D4017-9	2	16	0
	D4020-11	2	27	0
	D4021-1	3	42	0
	D4034-041	1	7	0
	D4034-043	1	7	0
	D4672-1	2	50	0
	M304EX0.75-16F	33	1,120	0
150-HandFinish	AN3-10A	6	237	0
	D2931	2	1,080	0
	D4021-5	2	26	0
	MS20600-AD4W3	2	273	0
	MS21042L3	6	2,861	0
	NAS1149F0332P	12	3,047	0

Part Specifications

Specifications could not be found.

Plex 4/18/18 1:06 PM Dart.Gagnon.Michelle



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Container No: S071066



Part: D3913-041

Job No: 176188

Serial No/Batch: S071066

Revision:

Inspector:

Date: 05/14/18